

Date: Wednesday, 9/26/2007 2:07:20 PM
 User: Kim Johnston

Process Sheet

42

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL HIGH BACK SEAT
 Job Number : 34885
 Estimate Number : 12271
 P.O. Number :
 This Issue : 9/26/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D350689041
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : IIN-D350-689 PG9
 Previous Run : 34300 Drawing Revision : A
 Material :
 Due Date : 10/15/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev.H Removed Sub-Parts 06-02-09 JLM
 Est Rev.I As per NCR 070 06-09-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D30231 Back Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3023-1 Back Panel B36149

8/01/16

8/3 08/02/06 ①

2.0 D3017041 Back Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3017-041 Back Assembly B36149

8/01/16

8/3 08/02/06 ①

3.0 MS20600AD4W2 Rivet



Comment: Qty.: 40.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

40 ms20600ad4w2 Rivet 4747

4.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Cherry Rivets

Batch: M18071

8/01/16 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 34885

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

MF 08-02-06

(1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/06 (40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

FJ 08/02/07

(1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/02/07

(X)

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer B 33368

SB 08/02/11

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud B 33369

X B 33369

NOT
BAD
PLATED

FOR HAI 2 NY

11.0

D30291

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring B 24962

SB 08/02/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 34885

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30301

Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock B24631

SB 08/02/11

13.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop B33404

SB 08/02/11

14.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt M103947

SB 08/02/11

15.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer M104885

mi 2008/12/12

16.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3) M105558

SB 08/02/11

17.0

MS24693S272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw M04746

SB 08/02/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 34885

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS27039117

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw m11540

SB 08/02/11

19.0

MS27039119

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw m10089

SB 08/02/11

20.0

D30221

Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3022-1 Seat Pan B3648

SB 08/02/11

21.0

D3021041

Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3021-041 Tube Assembly B3647

SB 08/02/11

22.0

D3016041

Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3016-041 Frame Assembly B3645-11

SB 08/02/11

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

08 02 11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 34885

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1008-02-12

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

HAI

00200

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1008-02-12

Job Completion



mi 2008/2/12

1

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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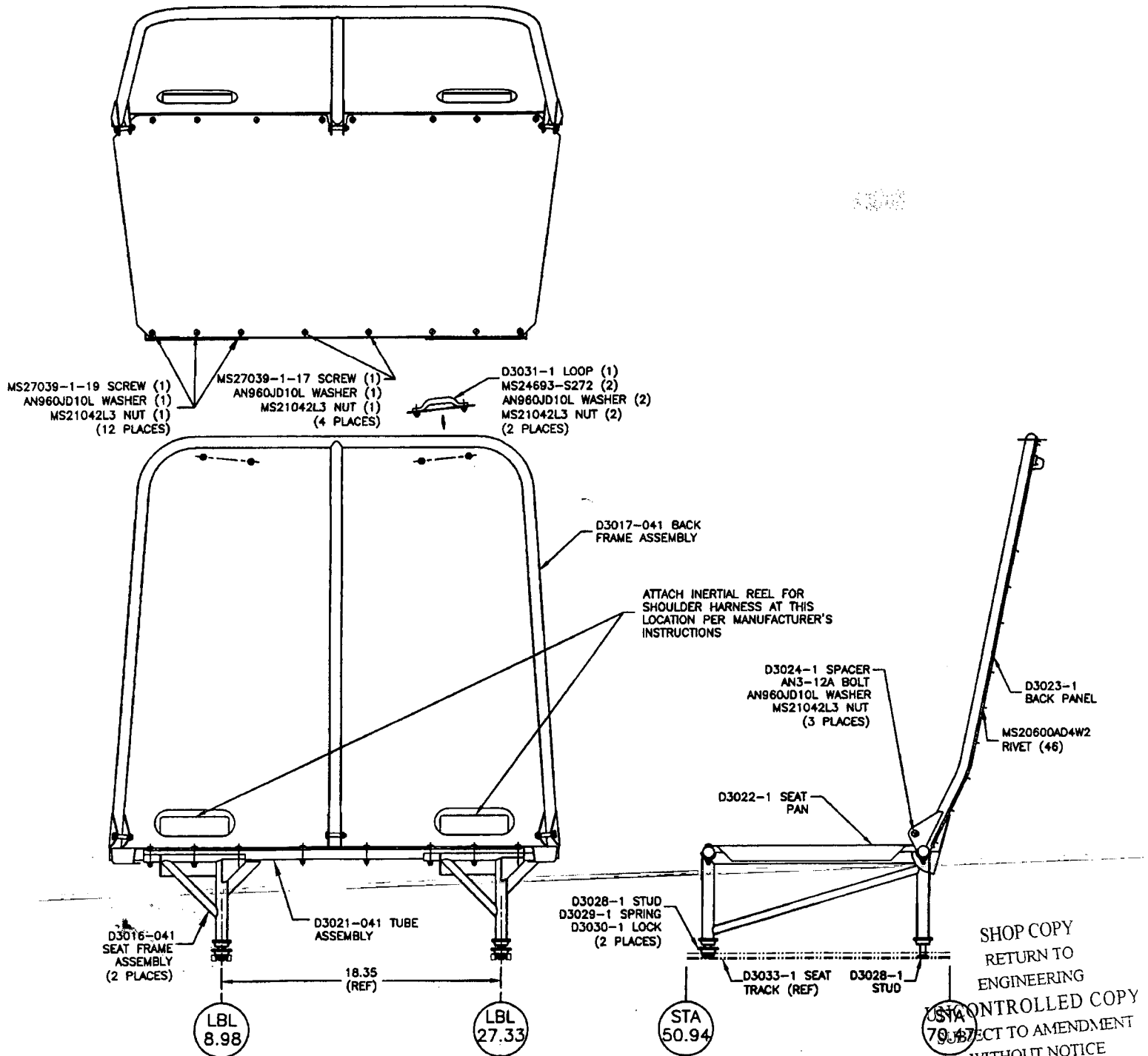


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A
Date: 01.05.30

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9349	REV. A SHEET 1 OF 1
DATE 06.08.16		TITLE RIVET CHANGE	SCALE NTS
A	06.08.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 Rev.A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 Rev.0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

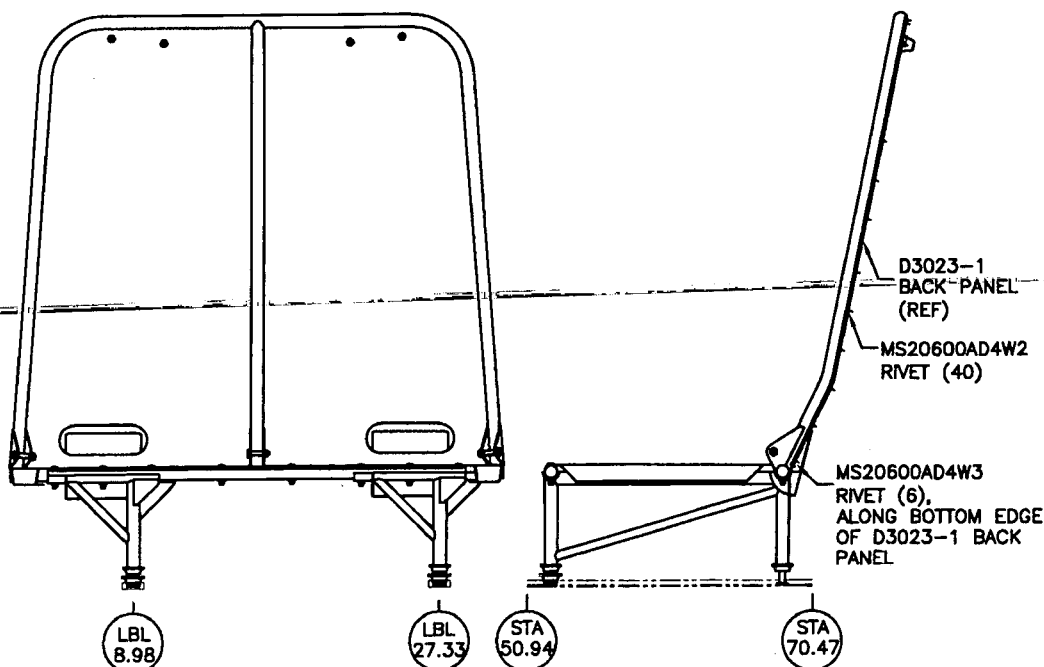
Some rivet lengths have changed, as indicated below, to ensure proper assembly of the D350-689-041 Dual High Back Seat Assembly. If installing replacement parts, it is acceptable to use longer rivets in other locations as required to ensure proper fastening. The parts list is revised as follows:

WAS:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
46	MS20600AD4W2	RIVET

NOW:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. **34885**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.08.16
CERT. NO.: SH02-33
ISSUE NO.: 1

D350-689-041 Dual High Back Seat Assembly

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